

Work Order ID 109345

November-20-13 9:12:23 AM

\*109345\*

Page 1

Item ID: D3691-041

Revision ID:

Item Name: Stud Assembly

Start Date: 11/20/13 Start Qty: 14.00

Required Date: 12/04/13 Req'd Qty: 14.00

Reference:

Approvals:

Process Plan: MLJ

Date: 13-11-20 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3691	E
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100	Pick Kit	0.00
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\*100\*

Packaging Memo 0.00

Packaging

14 13/12/05  
SAD

110	Small Fab	0.00
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\*110\*

Small Fab Memo 0.00

Small Fab

1-Align the pilot holes in mating parts. Drill out each hole using pilot drill and ream each hole using a step reamer. Clean and deburr all holes prior to assembly as per dwg. (SEE NOTE 8)

\*\*\*AFTER FINISH DRILLIN AND REAMING PARTS MUST STAY TOGETHER. DO NOT MIXE THEM UP\*\*\*

2-Assemble D3693-1 with D3691-1 Using Hysol EA934NA or MAGNOBOND 6398 adhesive between mating surfaces as per Dwg D3684

(H) 13/12/05 SAD

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 109345

\*109345\*

Page 2

November-20-13 9:12:23 AM

Item ID: D3691-041

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Stud Assembly

Start Date: 11/20/13 Start Qty: 14.00

\*14\*

Cust Item ID:

Required Date: 12/04/13 Req'd Qty: 14.00

\*14\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	DAS 27 9-89	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC5- Inspect part completeness to step on W/O

0.00

\*120\*

QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location: SA 0.00

\*130\*

Packaging

\*\* Use mesh sleeve to protect thread \*\*

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release 0.00

\*140\*

QC

Memo

0.00

Quality Control

14x DAS 28 9-89 13-12-9

13/12/10

13-12-9

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



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### FAULT CATEGORY

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# Picklist Print

November-20-13 9:12:27 AM

Page 1 / 2

Work Order ID: 109345

\*109345\*

Parent Item: D3691-041

\*D3691-041\*

Parent Item Name: Stud Assembly

Start Date: 11/20/13

Required Date: 12/04/13

Start Qty: 14.00

Required Qty: 14.00

Comments: IPP REV:A 13.01.24 PERECN12-693 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3691-1		Manufactured	No				Each	30.0000		14			
*D3691-1*									**				
Stud													

Location	Loc Qty	Loc Code
ST224	6	
96696	3	
97834	3	
ST225	24	
103882	12	
105609	12	

D3693-1		Manufactured	No				Each	11.0000		14			
*D3693-1*									**				
Rod End Bearing													

Location	Loc Qty	Loc Code
GA	11	
*101467	6	
102298	4	
89063	1	

HL32PB8-14		Purchased	No				Each	124.0000		28			
*HL 32PB8-14*									**				
Pin													

Location	Loc Qty	Loc Code
ST284	124	
123916	4	
125436	120	

SAD 13/12/02

SAD 13/12/02

SAD 12/12/02

28

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



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### FAULT CATEGORY

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# Picklist Print

Page 2

November-20-13 9:12:27 AM

Work Order ID: 109345

**\*109345\***

Parent Item: D3691-041

**\*D3691-041\***

Parent Item Name: Stud Assembly

Start Date: 11/20/13

Required Date: 12/04/13

Start Qty: 14.00

Required Qty: 14.00

HL86-8

Purchased

No

Each

160.0000

28

**\*HI 86-8\***

\*\*

*SAD 13/12/02*

Collar

Location

Loc Qty

Loc Code

ST284

160

124724

7

125436

53

m126267

100

*28*  
*10*

November-20-13 9:12:27 AM

Shop Packet Print

Page 2

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

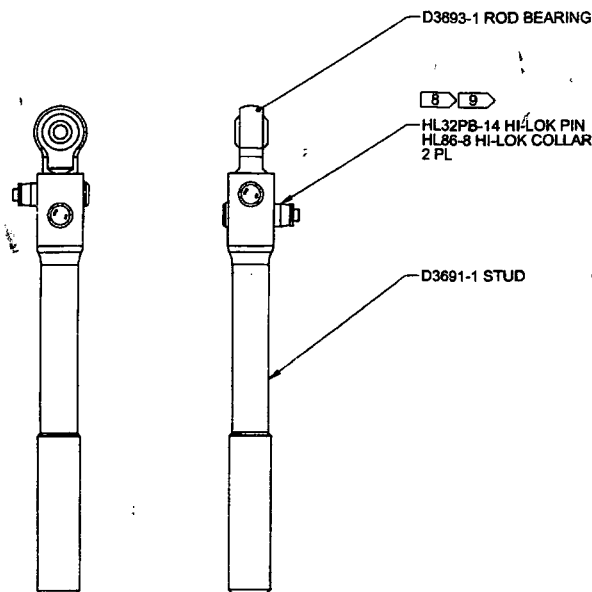
### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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ITEM	QTY	P/N	DESCRIPTION
1	3X	D3691-041	STUD ASSEMBLY
2	1	D3691-1	STUD
3	1	D3693-1	ROD END BEARING
4	12	HL32PB8-14	HI-LOK PIN
5	2	HL86-8	HI-LOK COLLAR

E



E D3691-041 STUD ASSEMBLY

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.04 lbs
- 8) ALIGN THE PILOT HOLES IN D3693-1 WITH PILOT HOLES IN D3691-1. ENLARGE EACH HOLE USING A P/N 13-420 PILOTED DRILL (0.2314 DIA./0.2158 PILOT). REAM EACH HOLE USING A P/N 44-300 STEP REAMER (0.247 DIA./0.2314 PILOT). CLEAN AND DEBURR ALL HOLES PRIOR TO ASSEMBLY.
- 9) ASSEMBLE D3693-1 WITH D3691-1 USING HYSOL EA934NA OR MAGNOBOND 8398 ADHESIVE BETWEEN MATING SURFACES.

E

D3693-1 ROD BEARING

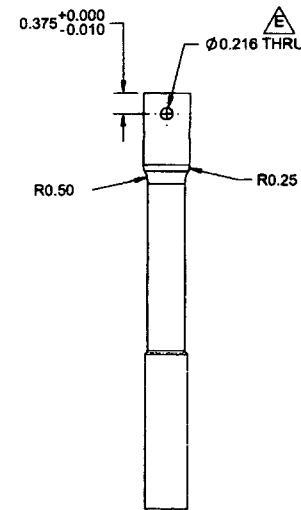
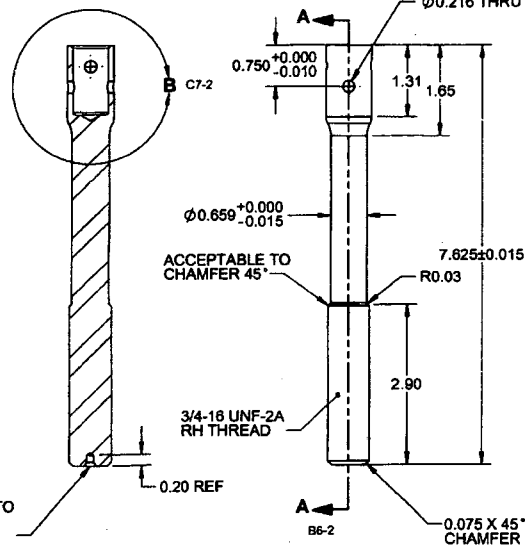
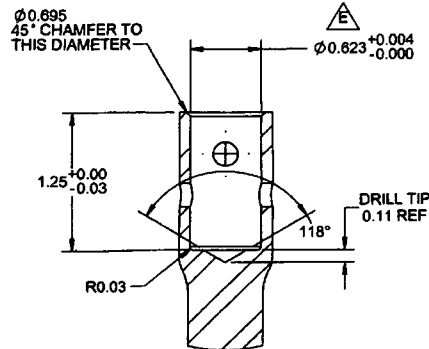
HL32PB8-14 HI-LOK PIN  
HL86-8 HI-LOK COLLAR  
2 PL

D3691-1 STUD



109345 MLC  
13-11-20

RELEASED  
2013-07-22

E	ADD -041 STUD ASSEMBLY, ASSEMBLY INSTRUCTIONS (ZN A8-1, ZN B6-1, ZN D7-1), Ø0.218 WAS Ø0.189 (ZN D2-4, D4-2), Ø0.823 WAS Ø0.825 (ZN D7-2), RE-FORMAT NOTES SECTION AS PER QSI 043 (ZN A8-1), REF NCR 12-2074		DB	12.12.07
D	7.625 WAS 7.750 (ZN C4-1)		RF	10.03.03
C	0.28 WAS 0.16 & CENTER DRILL #2 WAS CENTER DRILL #2 (ZN B6-1) UPDATE NOTE 8 TO REF QSI (ZN A8-1)		RF	09.09.08
B	CHANGE TO 17-4PH H-900 (ZN A8-1), Ø0.635 WAS Ø0.565 (ZN D8-1) REFORMATTED TO CURRENT DWG STANDARDS		RF	08.11.24
A	NEW ISSUE		RF	08.03.12
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	DB			
CHECKED	MB	DRAWING NO.		REV. E
MFG. APPR.	JLM	D3691		SHEET 1 OF 2
APPROVED		TITLE		SCALE
DE APPR.		STUD		NTS
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- NOTES:
- 1) MATERIAL: 17-4PH STAINLESS STEEL ROUND BAR PER AMS 5643 H-900 CONDITION
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.80 lb
  - 8) LPI PER QSI 038 4.1.1 (ASTM E1417 LEVEL 2)

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MB	DRAWING NO.	REV. E
MFG. APPR.	JLM	D3691	SHEET 2 OF 2
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R 2013-01-22